



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

646.3301

Job Sheet 207884



Part No: 646.3301

Job Qty: 2 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/5/20

Job Tracking No:

Due Date: 4/17/20

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3300 REV.A IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.07 AS PER DWG
NC3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	2 pcs		4/17/20	0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

MAR 10 2020



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL : 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Container No: S262465



Part: 646.3301

Job No: 207884

Serial No/Batch: S262465

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Date: 03/10/20

					Packaging 1 - 31	
					Packaging 1 - 32	
					Packaging 1 - 33	
					Packaging 1 - 34	
					Packaging 1 - 35	
					Packaging 1 - 36	
					Packaging 1 - 37	
					Small Fab - 1 - B4B	
					Small Fab - 2 - B4B	
120 Small Fab - 2 - B4B	2 pcs	4/17/20	0.00 2.50		Small Fab - 3 - B4B	
					Small Fab - 4 - B4B	
					Small Fab - 5 - B4B	
					Small Fab - 6 - B4B	
					Small Fab - 7 - B4B	
					Small Fab - 8 - B4B	
					Small Fab - 9 - B4B	
					Small Fab - Various 1 - B4B	
130 QC 5	2 pcs	4/17/20	0.00 0.00		QC 5 - 10	
					QC 5 - 12	
					QC 5 - 17	
					QC 5 - 18	
					QC 5 - 19	
					QC 5 - 22	
					QC 5 - 24	
					QC 5 - 3	
					QC 5 - 43	
					QC 5 - 49	
					QC 5 - 51	
					QC 5 - 58	
					QC 5 - 68	
					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
140 Packaging 3-1 - Stock - B4B	2 ✓ pcs	4/17/20	0.00 0.00		Packaging 3 - 1 - B4B	
					Packaging 3 - 2 - B4B	
					Packaging 3 - 3 - B4B	
					Packaging 3 - 4 - B4B	
					Packaging 3 - 5 - B4B	
					Packaging 3 - 6 - B4B	
					Packaging 3 - 7 - B4B	
					Packaging 3 - 8 - B4B	
					Packaging 3 - 9 - B4B	
					Packaging 3 - 10 - B4B	
					Packaging 3 - 11 - B4B	
					Packaging 3 - 12 - B4B	
					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	

MAR 12 2020

DAS
58
9-89

MAR 13 2020

DAS
80
9-89

CCK018

MAR 13 2020

				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
				Packaging 3 - 37 - B4B	
150 QC 21 - SA	2 ✓ pcs	4/17/20	0.00 0.00	QC 21 - SA - 21 ✓	CCK018
				QC 21 - SA - 70	
				QC 21 - SA - 53	

Part Op 110 - Pick Kit

Descriptions: 120 - Small Fab - TWO fastener must be install finger-tight (see note 9) Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7. exp. date: 05-21-2020

130 - QC5- Inspect part completeness to step on W/O

140 - Identify as per dwg & Stock Location: _____ ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3310	LH Half - Upper Cutter Assembly	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S223451
646.3311	RH Half - Upper Cutter Assembly	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S224197
646.3312	Center Plate	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S222136
646.3313	Upper Guide	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S222200
646.3314	Blade	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S250736
646.3315	Blade	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S248652
646.3316	Blade	2 pcs (1 ea)	110-Packaging 1 - Pick Kit	S247952
AN3-12A	Bolt	4 Ea (2 ea)	110-Packaging 1 - Pick Kit	S166926
AN3-14A	Bolt	2 Ea (1 ea)	110-Packaging 1 - Pick Kit	S112900
MS21042L08	Nut	36 Ea (18 ea)	110-Packaging 1 - Pick Kit	S250462
MS21042L3	Nut	6 Ea (3 ea)	110-Packaging 1 - Pick Kit	S248051
MS27039-08-19	Screw	36 Ea (18 ea)	110-Packaging 1 - Pick Kit	S250577
NAS1149F0332P	Washer (AN960-10L)	12 Ea (6 ea)	110-Packaging 1 - Pick Kit	S237779
NAS1149FN832P	Washer (AN960-8)	72 Ea (36 ea)	110-Packaging 1 - Pick Kit	S248050

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3310	2	8	0
	646.3311	2	8	0
	646.3312	2	9	0
	646.3313	2	23	0
	646.3314	2	27	0
	646.3315	2	29	0
	646.3316	2	30	0
	AN3-12A	4	136	0
	AN3-14A	2	146	0
	MS21042L08	36	2,012	0
	MS21042L3	6	2,879	0
	MS27039-08-19	36	693	0
	NAS1149F0332P	12	4,393	0
	NAS1149FN832P	72	4,543	0

Part Specifications

Specifications could not be found.

Plex 3/5/20 3:14 PM Dart.lajeunesse.marie

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE



NCR No.

Route update only

Job: _____ Part No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐		DEPARTMENT/PROCESS Skid-tube ☐ Cross tube ☐ Eng. (Non-AW) ☐ Engineering ☐ Machining ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Water Jet ☐ Large Fab ☐ Finishing ☐ Rec/Store/Packaging ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QS1042)			
Description Work Order Deviation		Disposition		Completed By			
				Lead hand / Supervisor			
				QC / QA Coordinator			

Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY Contamination ☐ Power Loss/Surge ☐ Positioned Wrong ☐ Misaligned/off center ☐ Folio/Program ☐ Outside Tolerance ☐ BOM/Route ☐ Grain Direction ☐ Drawing ☐ Broken/Damage/Defect ☐ Weld ☐ Finish ☐ Incomplete/Unclear Instructions ☐ Wrong Stock Pulled ☐ Part Lost/Missing ☐ Drill Holes ☐ Out of Sequence ☐ Misread ☐ Fit/Function ☐ Off-set/Set-up ☐									
		Other/Details:									